

# Work Order ID 52869

October 16, 2009 10:07:00 AM



Page 1

Item ID: D206-642-541

Accept



Setup Start



Revision ID: M

Stop



Item Name: Replacement Skidtube

Start Date: 16/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *BS*

Date: *09-10-16*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

IIN-D206-642

Rev M

100

0.00



DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy bluefile & type labels per PPP D206-642-541

CHG003

*N/A*

# Work Order ID 52869

October 16, 2009 10:07:00 AM



Page 2

Item ID: D206-642-541

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Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

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Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110

0.00



Skidtubes

Skidtubes

0.00

Memo

1- Bend FWD end of tube using bend prog D3274 FWD dwg D3274, cut fwd end of tube with saw table setup D3274.

*DE 9-10-19*

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

*SAO 09-10-21*

3- weld fwd cap as per dwg D3274 and OSI004

AR Aluminum Rod Batch:

*m107213/m111999*

*BE 09-10-22*

4- grind fwd cap weld on top surface only

*BE 09-10-22*

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

*M 9-10-22*

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

**Work Order ID 52869**

Page 3

October 16, 2009 10:07:00 AM

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Item Name: Replacement Skidtube

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Required Date: 02/11/2009 Req'd Qty: 1.00



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Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

| Sequence ID/<br>Work Center ID          | Operation<br>Description                                  | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|---|---|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 120<br><br>HandFinish<br>Hand Finishing | Chemical Conversion Coat per QSI005 4.1<br><br>Memo       | 0.00<br><br>0.00     | SAD 09-10-22   |              |              |               |               |                  |                |
| 130<br><br>QC<br>Quality Control        | QC3- Inspect Part Finish<br><br>Memo                      | 0.00<br><br>0.00     |                |              |              |               |               | 11 9-10-22       |                |
| 140<br><br>QC<br>Quality Control        | QC5- Inspect part completeness to step on W/O<br><br>Memo | 0.00<br><br>0.00     | 2) 801/6/22    |              |              |               |               |                  |                |

# Work Order ID 52869

October 16, 2009 10:07:00 AM



Page 4

Item ID: D206-642-541

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Setup Start



Revision ID: M

Stop



Item Name: Replacement Skidtube

Start Date: 16/10/2009 Start Qty: 1.00



Cast Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150



Skidtubes

0.00

Skidtubes

0.00

Skidtubes

Memo

1-Open Ø0.313" and 0.375" crossbolt spacer holes using DT8743 as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R ☐ Sikaflex-291 ☒ 11/23/09 ☐

Sikaflex expire date: ☐ 12-2-20 ☐

Start: ☐ 9-10-22 ☐ Time: ☐ 3:00pm ☐

Finish: ☐ 9-10-22 ☐ Time: ☐ 9:00am ☐

(Adhere for 12 hours)

9/10/26

10:10am

D

119-0-22

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

SS 10/26

Ⓟ

/

# Work Order ID 52869

October 16, 2009 10:07:00 AM



Page 5

Item ID: D206-642-541

Accept



Setup Start



Revision ID: M

Stop



Item Name: Replacement Skidtube

Start Date: 16/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-IT2  
OPEN HOLES TO .297" . Deburr

3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT895 FWD  
END OF TUBE  
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)  
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

*DP 9-10-26*

*BE 9-10-26*

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*250/10/26*



*h = 3.00"*

*L = 4.6"*

# Work Order ID 52869

October 16, 2009 10:07:00 AM



Page 6

Item ID: D206-642-541

Accept



Setup Start



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Stop



Item Name: Replacement Skidtube

Start Date: 16/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

190

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod  
A/R ☐ Aluminum Rod ☒ M112507

BE 09/10/27

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr.

DP 9-10-28

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

=> 809/10/28

(41) 0

Quality Control

# Work Order ID 52869



Page 7

October 16, 2009 10:07:01 AM

Item ID: D206-642-541

Accept



Setup Start



Revision ID: M

Stop



Item Name: Replacement Skidtube

Start Date: 16/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

| Sequence ID/<br>Work Center ID          | Operation<br>Description  | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|---|---|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 210<br><br>QC<br>Quality Control        | QC10- Inspect visual per QSI004- ground welds<br><br>Memo   | 0.00<br>0.00         | → S 09/10/28   |              |              | (XL)          |               |                  |                |
| 220<br><br>HandFinish<br>Hand Finishing | Pressure Wash per QSI005 4.3<br><br>Memo  | 0.00<br>0.00         | → H 09/10/28   |              |              | (X)           | ✓             |                  |                |
| 230<br><br>Powdercoat<br>Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum<br>M112148<br>Memo<br>START TIME: 7:30 AM<br>OVEN TEMPERATURE: 320°F<br>FINISH TIME: 8:00 AM | 0.00<br>0.00         | = H 09/10/28   |              |              | (XL)          | ✓             |                  |                |

# Work Order ID 52869



Page 8

October 16, 2009 10:07:01 AM

Item ID: D206-642-541  
Revision ID: M  
Item Name: Replacement Skidtube

Accept



Setup Start



Stop



Start Date: 16/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

| Sequence ID/<br>Work Center ID | Operation<br>Description  | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 240<br>                        | QC3- Inspect Part Finish  | 0.00                 | mo 09/10/29    |              |              | X1            |               |                  |                |
| QC<br>Quality Control          | Memo  | 0.00                 |                |              |              |               |               |                  |                |
| 250<br>                        | HandFinishing   | 0.00                 |                |              |              | X1            |               |                  |                |
| HandFinish                     | Memo  | 0.00                 |                |              |              |               |               |                  |                |
| Hand Finishing                 | 1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.<br>A/R <input type="checkbox"/> N/A <input type="checkbox"/> LPS-3 <input type="checkbox"/> n/h  |                      |                |              |              |               |               |                  |                |
|                                | 2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a<br>A/R <input type="checkbox"/> <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> m 11/23/29 <input type="checkbox"/><br>Sikaflex expire date: <input type="checkbox"/> 10/20 |                      |                |              |              |               |               |                  |                |
| 260<br>                        | QC5- Inspect part completeness to step on W/O   | 0.00                 | 2) 8 or 10/29  |              |              | (X)           | f             |                  |                |
| QC<br>Quality Control          | Memo<br>Inspect Nut Plate & Inserts   | 0.00                 |                |              |              |               |               |                  |                |



# Work Order ID 52869

October 16, 2009 10:07:01 AM



Page 9

Item ID: D206-642-541

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Setup Start



Revision ID: M

Stop



Item Name: Replacement Skidtube

Start Date: 16/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

270

0.00



HAND FINISHING RESOURCE #1

HandFinish

Memo

0.00

Hand Finishing

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

A/R ☐ Sikaflex-291 ☐ m112391 ☐

Sikaflex expire date: ☐ 10/20

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: 11/4

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R ☐ Sikaflex-291 ☐ m112391 ☐

Sikaflex expire date: ☐ 10/20

MO 09/10/29

280

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) Seal 11/29

Ⓜ f

**Work Order ID 52869**

October 16, 2009 10:07:01 AM



Page 10

Item ID: D206-642-541

Accept



Setup Start



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Stop



Item Name: Replacement Skid tube

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Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

290

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

PP

520087

9/10/30sep

Q



Packaging

Memo

0.00

Packaging

300

QC21- Final Inspection - Work Order Release

0.00

09/11/02



QC

Memo

0.00

Quality Control

u 08.10.30

# Picklist Print

October 16, 2009 10:07:09 AM

Page 1

Work Order ID: 52869

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Start Date: 16/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2600-1-190RevD1                |                        | Manufactured  | No          |                     |                  | 110             | Each               | 65.0000        | 1.0000                   |               |                |        |



Extrusion Round 3" 206

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

65

47575

65

110

Each

27.0000

1.0000

D3285-1RevA

Manufactured

No



Cap

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

27

47635

27

150

Each

5.0000

1.0000

D3282-041RevC

Manufactured

No



Float Web (206L/407)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

5

48389

5

9-10-19

1

1 BG 09/10/22

1 11 9-10-22

# Picklist Print

October 16, 2009 10:07:09 AM

Work Order ID: 52869

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube


Comments:

Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name   | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2649RevB1  |                        | Manufactured  | No          |                     |                  | 190             | Each               | 593.0000       | 1.0000                   |               |                |        |
|  |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |
| Cross Bolt Spacer   |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| Main Warehouse   |                |                 |
| LG               | 83             |                 |
| 51529            | 83             |                 |
| Main Warehouse   |                |                 |
| ST               | 510            |                 |
| 36013            | 5              |                 |
| 47112            | 383            |                 |
| 48271            | 122            |                 |

D3275-1RevA1

Manufactured No

190

Each

28.0000

12.0000



Crossbolt Spacer

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| Main Warehouse   |                |                 |
| ST               | 28             |                 |
| 47464            | 1              |                 |
| 48117            | 15             |                 |
| 48270            | 12             |                 |

B 52510

12

DE 09/10/26

# Picklist Print

Page 3

October 16, 2009 10:07:09 AM

Work Order ID: 52869

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| CR3212-4-03                     |                        | Purchased     | No          |                     |                  | 250             | Each               | 310.0000       | 2.0000                   |               |                |        |



Cherry Rivet

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| Main Warehouse   |                |                 |
| ST               | 310            |                 |
| 111359           | 96             |                 |
| 112314           | 200            |                 |
| 15984            | 14             |                 |

X2 MD 09/10/29

D3415-041RevB

Manufactured No



Nut Plate

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| Main Warehouse   |                |                 |
| ST               | 93             |                 |
| 63842            | 93             |                 |

X1 MD 09/10/29

CCR264SS3-3

Purchased No



Cherry Rivet

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| Main Warehouse   |                |                 |
| ST               | 267            |                 |
| 111548           | 52             |                 |
| 111827           | 115            |                 |
| 112314           | 100            |                 |

X2 MD 09/10/29

October 16, 2009 10:07:09 AM

Shop Packet Print

Page 3

# Picklist Print

Page 4

October 16, 2009 10:07:09 AM

Work Order ID: 52869



Parent Item: D206-642-541RevM



Parent Item Name: Replacement Skidtube

Start Date: 16/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| ALS4-1032-130                   |                        | Purchased     | No          |                     |                  | 250             | Each               | 5,373.000      | 78.0000                  |               |                |        |
|                                 |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |

Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5373

110511

5373

270

Each

41.0000

1.0000

X78 mo 09/10/29

D3536-15RevA

Manufactured

No



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

41

47711

3

48159

12

51600

26

X1 mo 09/10/29

October 16, 2009 10:07:09 AM

Shop Packet Print

Page 4

# Picklist Print

Page 5

October 16, 2009 10:07:09 AM

Work Order ID: 52869



Parent Item: D206-642-541RevM



Parent Item Name: Replacement Skidtube

Start Date: 16/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|-----------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3536-23RevA                |                        | Manufactured  | No          |                     |                  | 270             | Each               | 30.0000        | 1.0000                   |               |                |        |
|                             |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |
| Gasket                      |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| Main Warehouse   |                |                 |
| FP               | 12             |                 |
| 51609            | 12             |                 |
| Main Warehouse   |                |                 |
| ST               | 18             |                 |
| 30754            | 1              |                 |
| 47713            | 17             |                 |

D3536-35RevA

Manufactured No

270

Each

39.0000

1.0000



Gasket

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| Main Warehouse   |                |                 |
| ST               | 39             |                 |
| 48160            | 13             |                 |
| 51628            | 26             |                 |

XI mo 09/11/029

XI mo 09/11/029

October 16, 2009 10:07:09 AM

Shop Packet Print

Page 5

# Picklist Print

Page 6

October 16, 2009 10:07:09 AM

Work Order ID: 52869

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube


Comments:

Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name   | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Rate<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3536-39RevA  |                        | Manufactured  | No          |                     |                  | 270            | Each               | 28.0000        | 1.0000                   |               |                |        |
|  |                        |               |             |                     |                  |                |                    |                |                          |               |                |        |
| Gasket  |                        |               |             |                     |                  |                |                    |                |                          |               |                |        |

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 12

51637 12

Main Warehouse

ST 16

44648 1

47714 4

48161 11

D3535-15RevB

Manufactured No



Wearshoe

270 Each 31.0000 1.0000



XI MD 09/10/29

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP 18

51671 18

Main Warehouse

ST 13

30750 4

42233 1

48155 8

XI MD 09/10/29

October 16, 2009 10:07:09 AM

Shop Packet Print

Page 6



# Picklist Print

Page 7

October 16, 2009 10:07:09 AM

Work Order ID: 52869



Parent Item: D206-642-541RevM



Parent Item Name: Replacement Skidtube

Start Date: 16/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3535-35RevB                    |                        | Manufactured  | No          |                     |                  | 270             | Each               | 36.0000        | 1.0000                   |               |                |        |
|                                 |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |

Wearshoe

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| Main Warehouse   |                |                 |
| ST               | 36             |                 |
| 48157            | 10             |                 |
| 51608            | 26             |                 |

XI MD 09/10/29

D3535-39RevB

Manufactured No

270 Each 26.0000 1.0000



Wearshoe

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| Main Warehouse   |                |                 |
| FP               | 13             |                 |
| 51619            | 13             |                 |
| Main Warehouse   |                |                 |
| ST               | 13             |                 |
| 48158            | 13             |                 |

XI MD 09/10/29

# Picklist Print

October 16, 2009 10:07:09 AM

Work Order ID: 52869



Parent Item: D206-642-541RevM



Parent Item Name: Replacement Skidtube

Start Date: 16/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3535-23RevB                    |                        | Manufactured  | No          |                     |                  | 270             | Each               | 24.0000        | 1.0000                   |               |                |        |
|                                 |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |
| Wearshoe                        |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

FP    13

51618    13

Main Warehouse

ST    11

48156    11

D3537-3RevC

Manufactured      No



Wearpad

270                      Each                      69.0000                      1.0000



Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST    69

30758    7

33881    17

35697    45

XI mo 09/10/29

XI mo 09/10/29

# Picklist Print

Page 9

October 16, 2009 10:07:09 AM

Work Order ID: 52869

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3537-1RevC                     |                        | Manufactured  | No          |                     |                  | 270             | Each               | 284.0000       | 9.0000                   |               |                |        |



Wearpad

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 2

48288 2

Main Warehouse

FP17 265

51624 103

51678 162

Main Warehouse

ST 17

51918 17

AN960C10L

Purchased

No

270

Each

4,396.000 80.0000



washer

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG 100

103585 100

Main Warehouse

ST 4296

112116 993

112612 3303

X9 mo 09/11/09/29

X80 mo 09/10/29

October 16, 2009 10:07:09 AM

Shop Packet Print

Page 9

# Picklist Print

Page 10

October 16, 2009 10:07:09 AM

Work Order ID: 52869

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube


Comments:

Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name  | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| AN960C416<br><br>washer |                        | Purchased     | No          |                     |                  | 270             | Each               | 704.0000       | 1.0000                   |               |                |        |

Warehouse  
Location  
Main Warehouse  
ST

Loc Qty

Loc Code

704

704

XI mo 09/10/29

D3672-1RevB

Manufactured

No



Phenolic Washer

270

Each

2,056.000 2.0000



Warehouse  
Location  
Main Warehouse  
ST

Loc Qty

Loc Code

1556

39275

19

42329

15

47628

522

52505

1000

X2 mo 09/10/29

Main Warehouse

ST117

500

51674

500

# Picklist Print

Page 11

October 16, 2009 10:07:10 AM

Work Order ID: 52869

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube


Start Date: 16/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name   | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| AN3C4A<br><br>BOLT |                        | Purchased     | No          |                     |                  | 270             | Each               | 1,826.000      | 80.0000                  |               |                |        |

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| Main Warehouse   |                |                 |
| ST               | 1826           |                 |
| 112314           | 40             |                 |
| 112720           | 124            |                 |
| 112724           | 178            |                 |
| 112794           | 984            |                 |
| 112829           | 500            |                 |

X80 mo 09/10/29

AN4C5A

Purchased

No

270

Each

601.0000

1.0000

BOLT

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| Main Warehouse   |                |                 |
| ST               | 601            |                 |
| 104936           | 19             |                 |
| 110552           | 80             |                 |
| 112243           | 500            |                 |
| 18918            | 2              |                 |

X1 mo 09/10/29

# Picklist Print

Page 12

October 16, 2009 10:07:10 AM

Work Order ID: 52869

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2646RevC                       |                        | Manufactured  | No          |                     |                  | 270             | Each               | 53.0000        | 1.0000                   |               |                |        |

Aft Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

53

20208

0

43801

1

46327

4

48109

48

D3413-1RevA

Manufactured No



Ring

270

Each

40.0000

1.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

20

48123

20

Main Warehouse

ST473

20

51586

20

XI MD 09/10/29

XI MD 09/10/29

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Page 12

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32869

**DART**

*BL 09-10-21*

RELEASED

07.02.12

DEO ATTACHED

|                  |                |  |                        |
|------------------|----------------|--|------------------------|
| DESIGN<br>CP     | DRAWN BY<br>PH | DART AEROSPACE USA, INC.<br>PORT HADLOCK, WA |                        |
| CHECKED<br>#     | APPROVED<br>#  | DRAWING NO.<br>D3274                         | REV. D<br>SHEET 1 OF 4 |
| DATE<br>06.12.19 |                | TITLE<br>SKIDTUBE ASSEMBLY                   | SCALE<br>NTS           |
| A                | 04.03.15       | NEW ISSUE                                    |                        |
| B                | 04.08.09       | MOVE SADDLE HOLE: 42.14 WAS 42.76            |                        |
| C                | 05.03.16       | ADD -043; NEW INSERTS                        |                        |
| D                | 06.12.19       | NEW INSERTS, SS WEARSHOE + GASKET            |                        |

| Qty<br>-041 | Qty<br>-043 | Part Number   | Description   |
|-------------|-------------|---------------|---|
| X           |             | D3274-041     | SKIDTUBE ASSEMBLY                                       |
|             | X           | D3274-043     | SKIDTUBE ASSEMBLY                                       |
| 1           | 1           | D2600-1-240   | EXTRUSION   |
| 1           | 1           | D2646         | AFT CAP   |
| 12          | 12          | D2649         | CROSS BOLT SPACER                                       |
| 12          | 37          | D3275-1       | CROSS BOLT SPACER                                       |
| 1           | 1           | D3282-041     | FLOAT WEB   |
| 1           | 1           | D3285-1       | CAP   |
| 1           | 1           | D3413-1       | RING  |
| 1           | 1           | D3415-041     | NUT PLATE   |
| 1           | 1           | D3535-15      | WEARSHOE  |
| 1           | 1           | D3535-23      | WEARSHOE  |
| 1           | 1           | D3535-35      | WEARSHOE  |
| 1           | 1           | D3535-39      | WEARSHOE  |
| 1           | 1           | D3536-15      | GASKET  |
| 1           | 1           | D3536-23      | GASKET  |
| 1           | 1           | D3536-35      | GASKET  |
| 1           | 1           | D3536-39      | GASKET  |
| 9           | 9           | D3537-1       | WEARPAD   |
| 1           | 1           | D3537-3       | WEARPAD   |
| 78          | 78          | ALS7-1032-130 | INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130) |
| 80          | 80          | AN3C4A        | BOLT  |
| 1           | 1           | AN4C5A        | BOLT  |
| 1           | 1           | AN960C416     | WASHER  |
| 80          | 80          | AN960C10L     | WASHER  |
| 2           | 2           | CCR264SS3-3   | RIVET   |
| 2           | 2           | CR3212-4-03   | RIVET   |
| 2           | 2           | NAS1515H3L    | WASHER  |

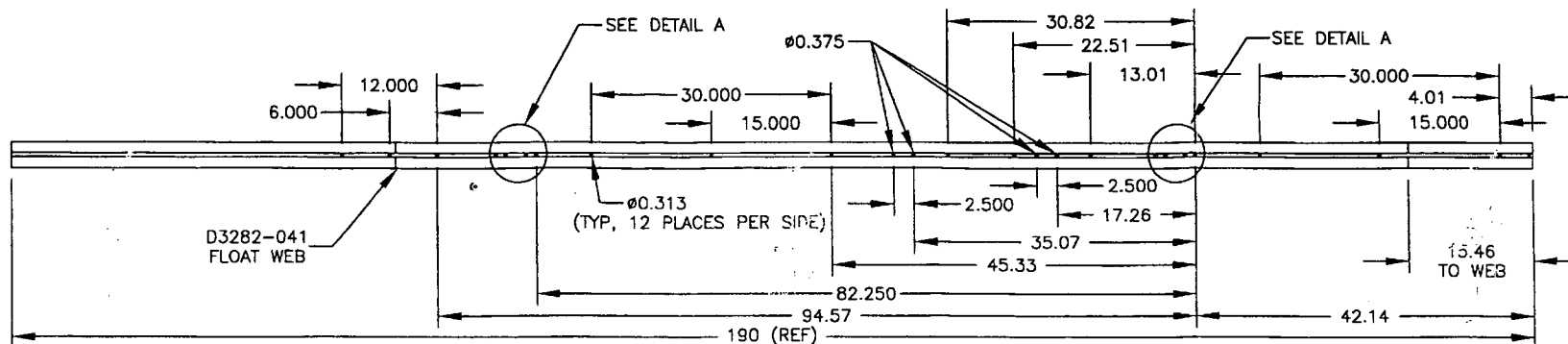
**GENERAL NOTES:**

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH. ALODINE ASSEMBLY PER DART QSI 005 4.1  
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

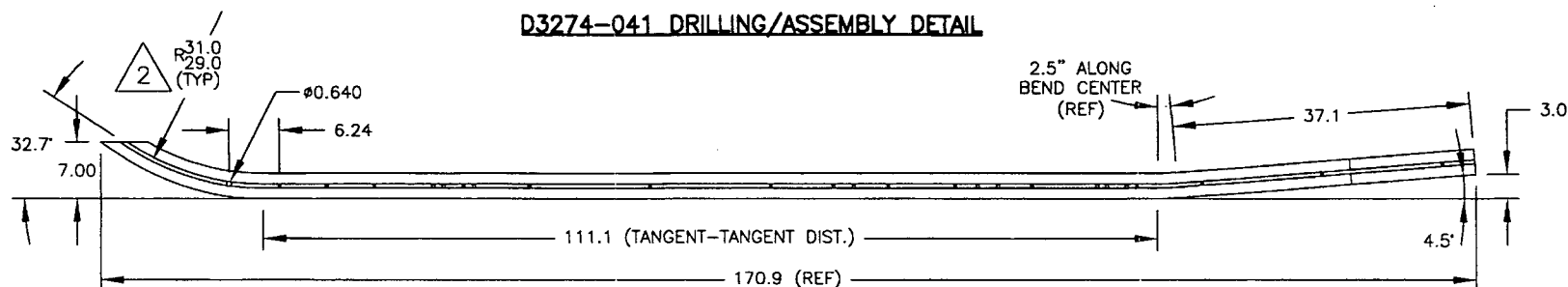
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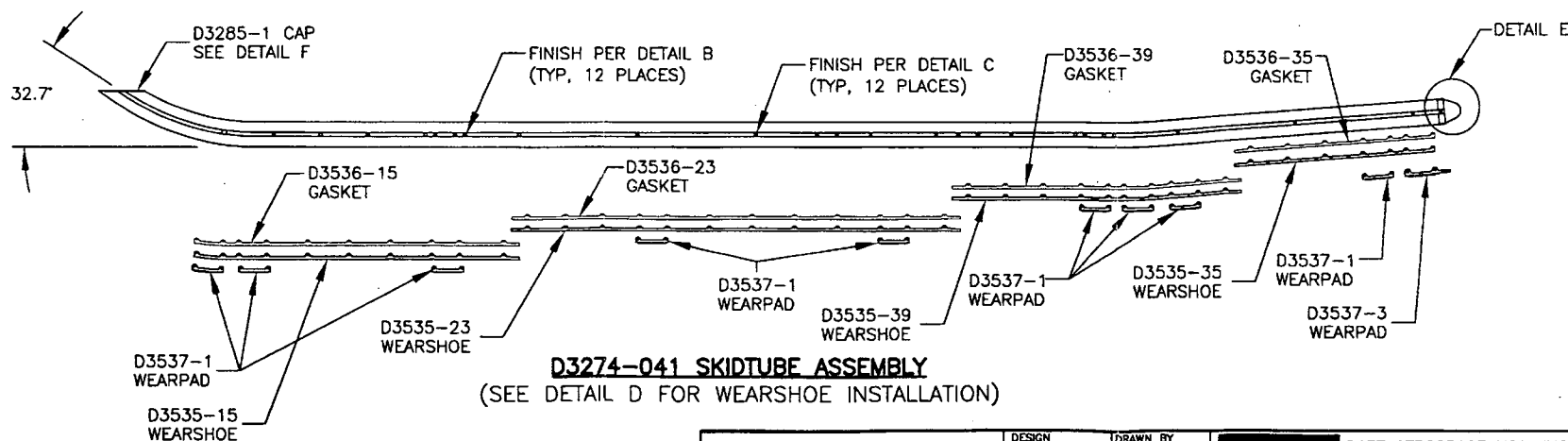
DEO ATTACHED



**D3274-041 DRILLING/ASSEMBLY DETAIL**



**D3274-041 BEND/DRILLING DETAIL**



**D3274-041 SKIDTUBE ASSEMBLY**  
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

w/o 52869

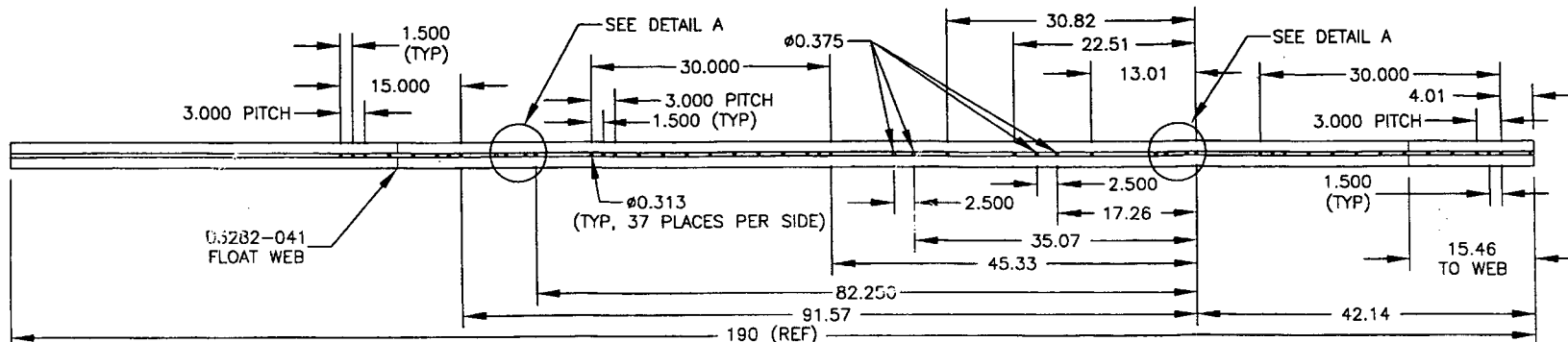
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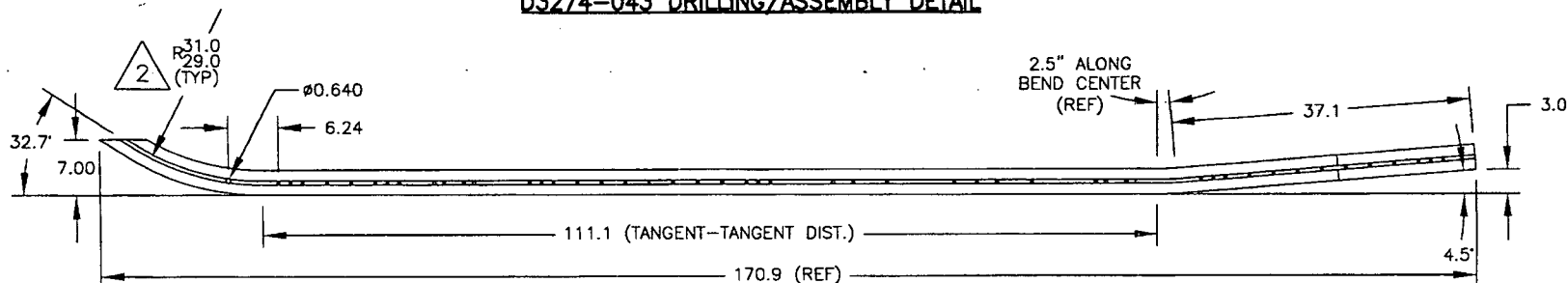
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| DESIGN  | CP       | DRAWN BY | PH                | <b>DART</b> DART AEROSPACE USA, INC.<br>PORT HADLOCK, MA |
| CHECKED | +        | APPROVED | +                 | DRAWING NO.<br>D3274                                     |
| DATE    | 06.12.19 | TITLE    | SKIDTUBE ASSEMBLY | REV. D<br>SHEET 2 OF 4<br>SCALE<br>1:15                  |



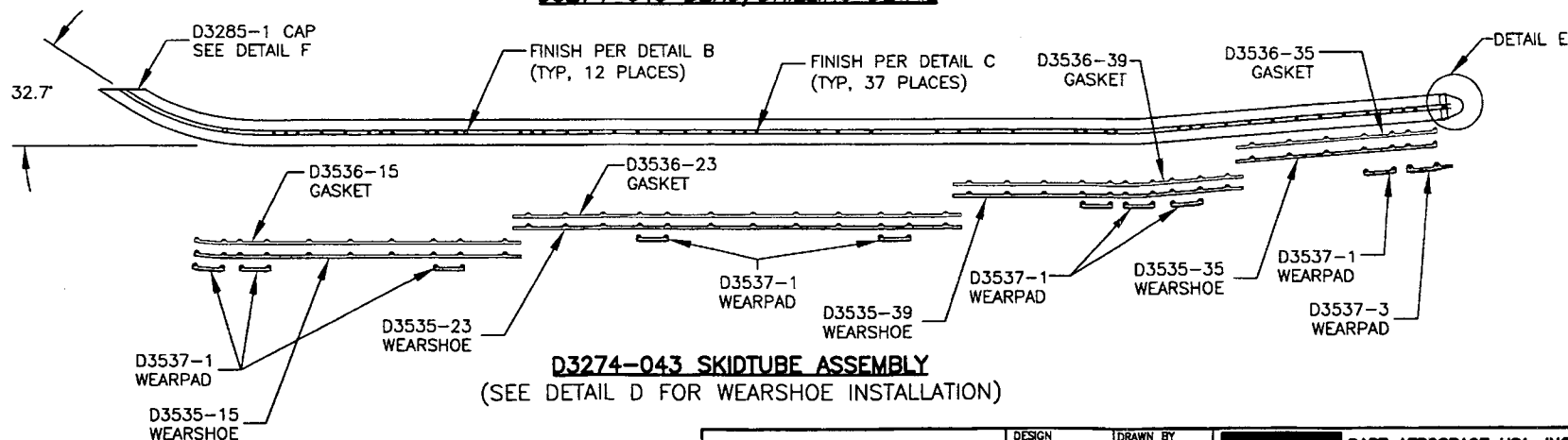
DEO ATTACHED



**D3274-043 DRILLING/ASSEMBLY DETAIL**



**D3274-043 BEND/DRILLING DETAIL**



**D3274-043 SKIDTUBE ASSEMBLY**  
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

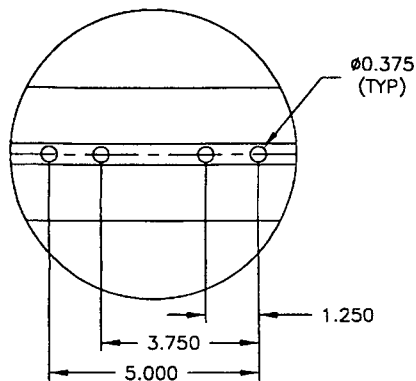
RELEASED

07-02-12

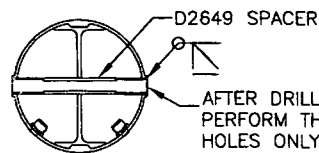
W/O 52869

|   |  |         |          |          |    |  |               |
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|   |  | DATE    | 06.12.19 | TITLE    |    | D3274  | SHEET 3 OF 4  |
|   |  |         |          |          |    | SKIDTUBE ASSEMBLY  | SCALE<br>1:15 |

# **DETAIL A: DRILL DETAIL**

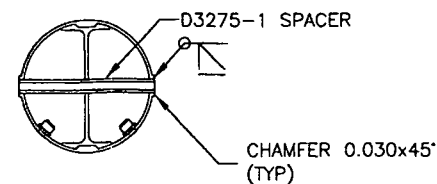


# **DETAIL B** FOR 0.375 HOLES ONLY

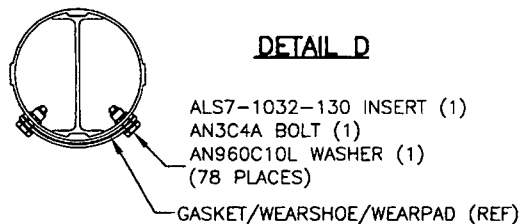


- AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR 0.375  
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
  2. INSERT D2649 SPACER
  3. WELD INTO PLACE AND GRIND FLUSH
  4. C'BORE TO 0.313x0.75 DEEP

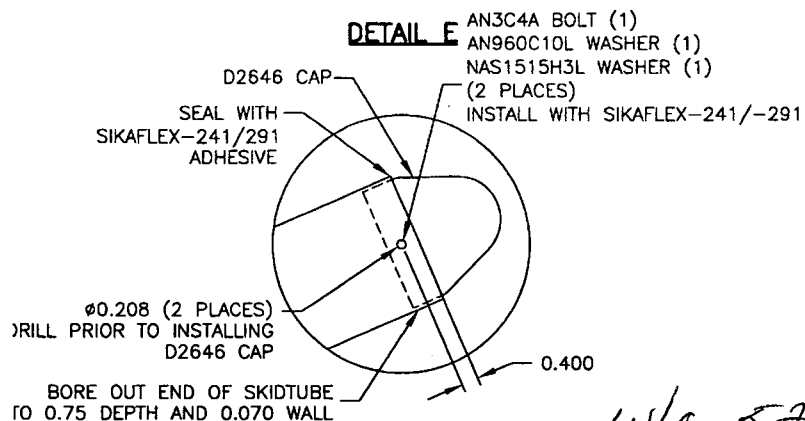
# **DETAIL C** FOR 0.313 HOLES ONLY



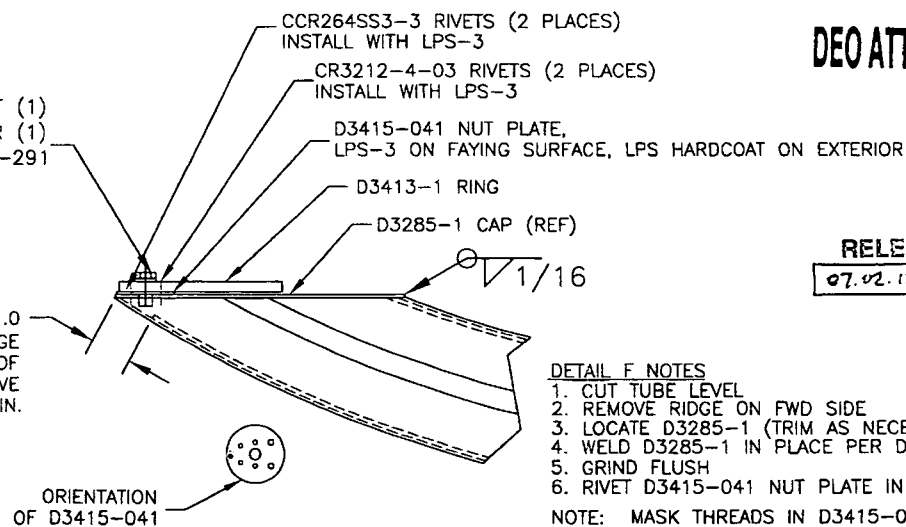
# **DETAIL D**



# **DETAIL E**



# **DETAIL F: END FINISHING DETAIL**



**DEO ATTACHED**

**RELEASED**  
07.02.12

- DETAIL F NOTES**
1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D3285-1 (TRIM AS NECESSARY)
  4. WELD D3285-1 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041  
PRIOR TO FINISH

|  |  |         |          |          |                   |  |
|--|--|---------|----------|----------|-------------------|--|
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|  |  | DATE    | 06.12.19 | TITLE    | SKIDTUBE ASSEMBLY |  |
|  |  |         |          | REV. D   | SHEET 4 OF 4      |  |
|  |  |         |          | SCALE    |                   | 1:3  |

WLO 57869

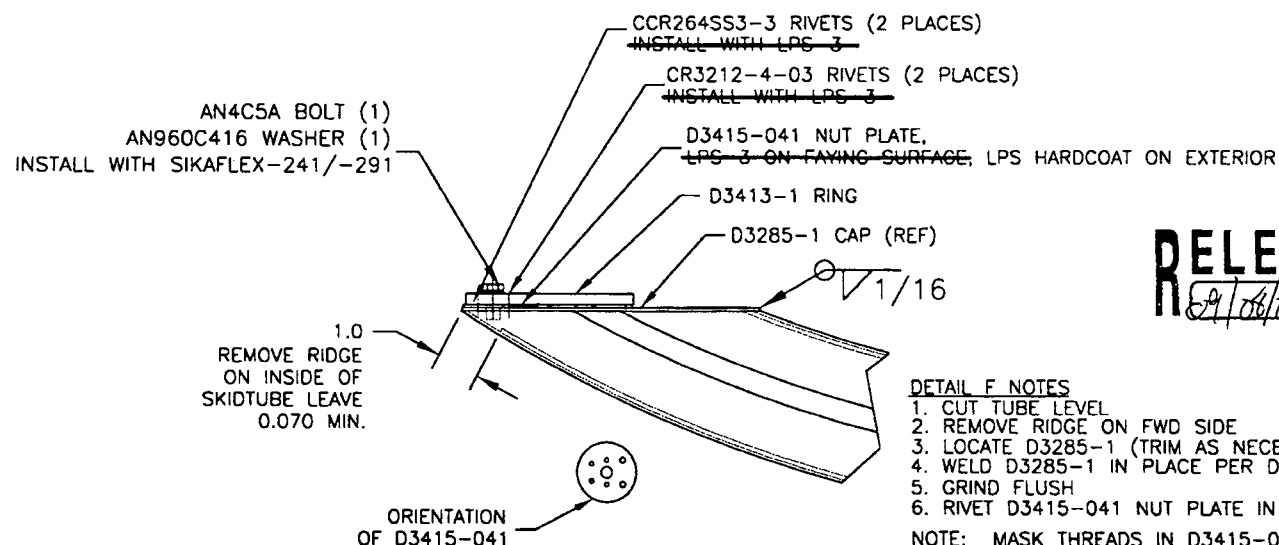
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|----------------------|-------------------------------|----------------------------------|--|--------------------------------|---------------------------|--------------|
| DRAWING NO.<br>D3274 | TITLE<br>SKIDTUBE ASSEMBLY    | REV. D                           | DART AEROSPACE USA, INC<br>ENGINEERING ORDER | D.E.O. NO.<br>D3274-D-1        | SHEET NO.<br>SHEET 1 OF 1 | SCALE<br>NTS |
| DRAWN<br><i>CP</i>   | CHECKED<br><i>[Signature]</i> | MFG. APPR.<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i>               | DE APPR.<br><i>[Signature]</i> |                           |              |
| DATE<br>09.06.17     | DATE<br>09.06.23              | DATE<br>09/06/23                 | DATE<br>09/06/23                             | DATE<br>09.06.23               |                           |              |

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: ~~"SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS-3' AFTER FINISH AND INSTALLATION OF INSERTS.~~  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

### DETAIL F: END FINISHING DETAIL



#### DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041  
PRIOR TO FINISH

*w/o 32869*

NO. 211

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 52411  
Part number: D206-642-541  
Description: 206 skid  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual:

pass[☒] fail[ ]  
pass[☒] fail[ ]

Penetration:

UNACCEPTABLE

Cracks:

pass[☒] fail[ ]

Undercut:

pass[☒] fail[ ]

Pin holes:

pass[☒] fail[ ]

Overlap (cold lap)

pass[☒] fail[ ]

Porosity (surface):

pass[☒] fail[ ]

Coloration:

pass[☒] fail[ ]

Qualifier Pct. Qual

Date of Test Coupon 09-10-09

Welder Barclay Elliott

Date of Test Coupon 09-10-09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld